

Rush

Work Order ID 159277

159277

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Friday, April 07, 2017 9:56:44 AM

Item ID: D2561 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 4/7/2017 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 4/11/2017 Req'd Qty: 60.00 *60* Customer:
 Reference: SCHEDULED/S APR 07 2017
 Approvals: Process Plan: DAS 21 9-89 Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2561	Rev B								
100		0.00					DAS 46 9-89		
100	FLOW WATER JET					60		17/04/07	
Waterjet	Memo	2.25							
FLOW CNC Waterjet	1-Cut as per Dwg D2561 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110		0.00					DAS 46 9-89		
110	QC2- Inspect parts off machine FAI/FAIB					60		17/04/07	
QC	Memo	0.60							
Quality Control									
120		0.00					DAS 38 9-89		
120	QC8- Inspect parts - second check					60			
QC	Memo	1.20							
Quality Control									

APR 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 1.20				<u>60</u>			DAS 38 3-89 APR 10 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>WAS</u> Memo *** STOCK IN STEP CELL*** LOCATION WA003	0.00 0.60				<u>60</u>		APR 10 2017	DAS 24 9-89
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 6.00					<u>17/4/11</u>		<u>JS</u> DAS 21 9-89 APR 10 2017



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Work Order update only ☐

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Picklist Print

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Work Order ID: 159277

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Parent Item: D2561

D2561

Parent Item Name: Lug

Start Date: 4/7/2017

Required Date: 4/11/2017

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP C 00.05.19Added inspect level 8EC
IPP Rev:D Now on Waterjet 06-06-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	15.6000	0.14	8.842105			
									**			DAS 46 9-89	17/04/07
M6061T6S 250													
6061T6 SHEET .250													

Location

Loc Qty

Loc Code

MAT020

15.6

m131352

15.6

65

DQA: _____ Date: _____



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